

DRAB GREEN

Dart Aerospace Ltd.

Date: Thursday, 20/11/2008 11:43:07 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number : 43567	
Estimate Number : 10534	
P.O. Number :	Part Number : D2574 W
This Issue : 20/11/2008 S.O. No. :	Drawing Number : D2574 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 42805	Material :
Written By :	Due Date : 04/12/2008 Qty: 4 Um: Each
Checked & Approved By : <u>JUL 08.11.20</u>	
Comment : Est Rev: I As Per RevE 06-01-27 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101005	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

7075-T7351 8.25X5.0X2.5

Make from D6101-005 billet for D2574

Ensure that grain is along 5.00" length

Batch No: B34874

DTP 08/12/03 (6)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1Program Batch No. 43567 Double check by: J.F.

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

DTP 08/12/07

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2573 & D2574

DTP 08/12/07

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE DTP 08/12/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 08/12/2008 7:20:19 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 43567

Part Number: D2574

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 08/12/08

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-1

08/12/08

6x

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

OLIVE DRAB GREEN

M 104476

M-1

08/12/08

6x

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

HL

08-12-08

6x

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

425

8/12/8

6x

SD

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/09

Job Completion



MF 08-12-08

DART AEROSPACE LTD		Work Order: 43567
Description: Saddle, Aft Inboard		Part Number: D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.440	0.440	0.4405	0.4405		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.005	8.005	8.005	8.005		
F	0.490	0.510		0.501	0.502	0.503	0.501		
G	0.257	0.262		0.259	0.259	0.259	0.259		
H	0.375	0.380		0.377	0.377	0.377	0.377		
I	0.490	0.510		0.503	0.499	0.501	0.502		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.570	0.568	0.569	0.670		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.126	0.128	0.128	0.127		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.249	0.250	0.250	0.250		
S	0.115	0.135		0.126	0.126	0.126	0.1		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.229	3.230	3.230	3.230		
V	0.230	0.250		0.232	0.232	0.235	0.235		
W	0.115	0.135		0.126	0.129	0.131	0.132		
X	0.307	0.312		0.311					
Y	0.760	0.765		0.760					
Z	0.352	0.372		0.362	0.361	0.361	0.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.625	0.623	0.621	0.622		
AC	0.053	0.073		0.0625	0.0625	0.0625	0.0625		
AD	0.240	0.260		0.242	0.240	0.242	0.2425		
AE	1.500	1.520		1.515	1.517	1.515	1.515		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.280	0.280	0.280	0.280		
AH	0.240	0.260		0.242	0.242	0.246	0.2465		
AI	2.000	2.020		2.007	2.009	2.004	2.004		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: DJP
Date: 08/12/06

Audited by: [Signature]
Date: 08/12/08

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	[Signature]

DART AEROSPACE LTD	Work Order: 43567
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. E	Page 1 of 1

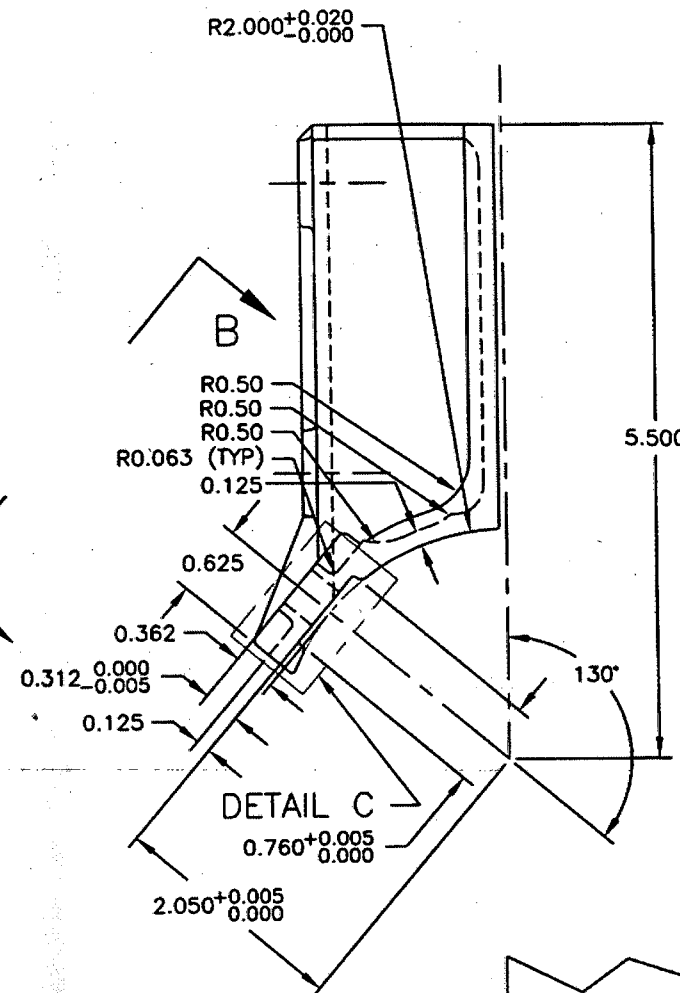
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Accept/Reject									

Measured by: DTP
Date: 08/12/07

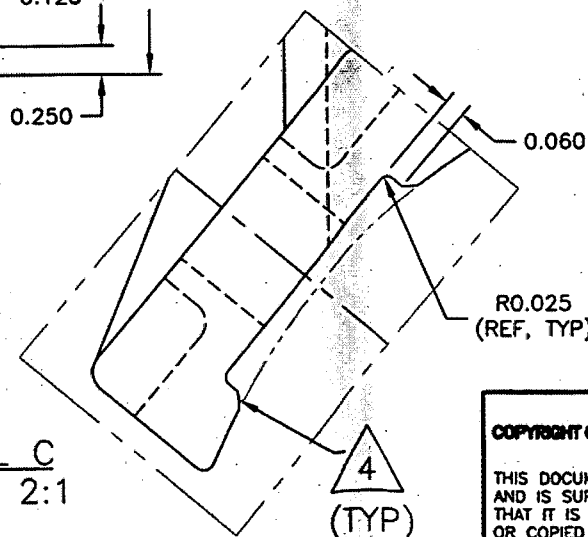
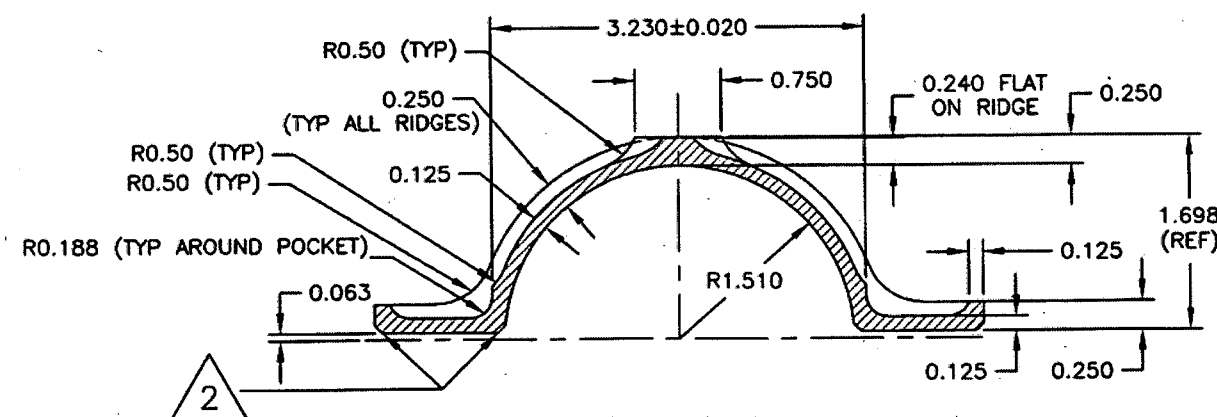
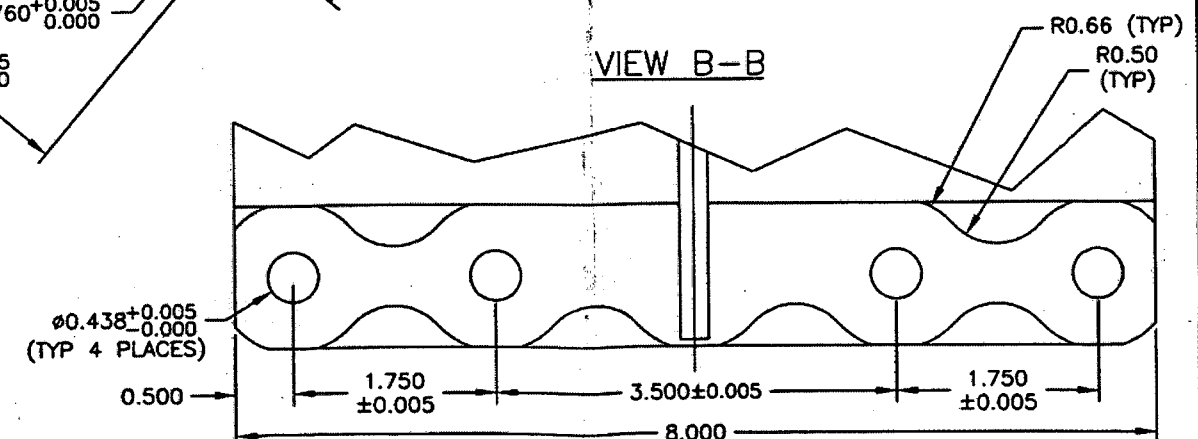
Audited by: SD
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05.12.06

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C) E



WITHOUT NOTICE
WORK ORDER
NO. 43567

